Date: Thursday, 02/04/2009 2:25:59 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BEARING
Job Number	: 46853		
Estimate Number	: 10091		
P.O. Number	:	**Part Number**	: D31835
This Issue	: 02/04/2009 **S.O. No.** :	**Drawing Number**	: D3183 REV. C1
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : PURCHASED PARTS	**Drawing Revision**	: C1
Previous Run	: 46392	**Material**	:
Written By	:	**Due Date**	: 14/04/2009 **Qty:** 40 **Um:** Each
Checked & Approved By	: JD 09.04.02		
Comment	: Est: A 03.03.27 New issue KJ/RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 8505
Bearing as per Dwg D3183
Single row, deep groove, Conrad type, shielded
Possible Supplier: NSK P/N 6800ZZ
Certificate of conformity note is required
CJ 09/04/03 (40)

2.0	6800ZZ	Bearing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of confomity is attached
09/4/7 (40)

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
counter
JD 09/04/08 (X40)

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 236
9/4/8
(40x)
SE

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:25:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BEARING

Job Number: 46853 **Part Number:** D31835

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

(40)
D 09/04/09
MF 09-04-08.

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

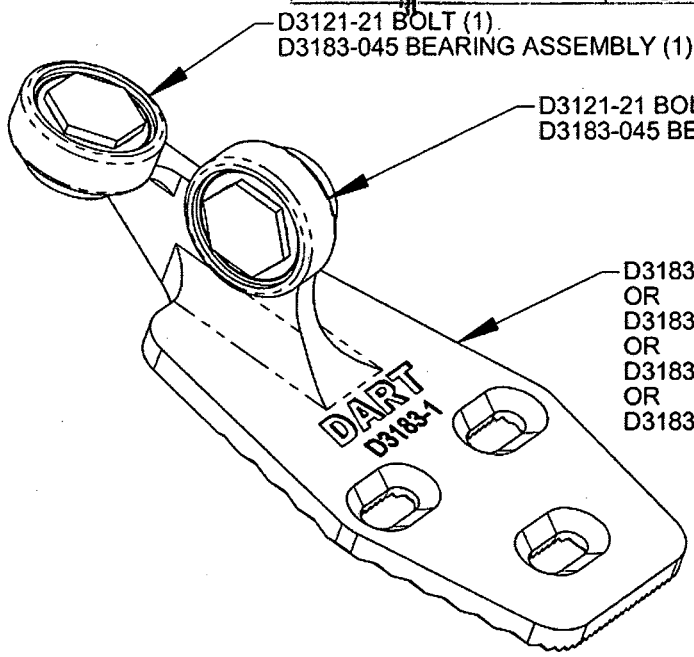
NOTE: Date & initial all entries

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

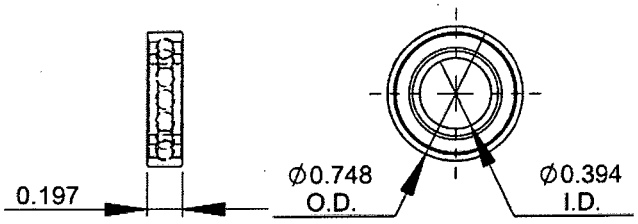
QA COPY ISSUED

RELEASED 04.03.01

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850

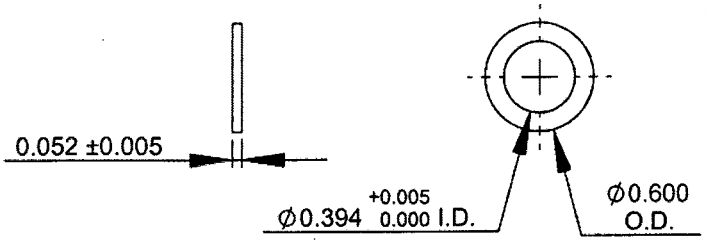


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) TOLERANCES ARE PER DART QSL018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 46805

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
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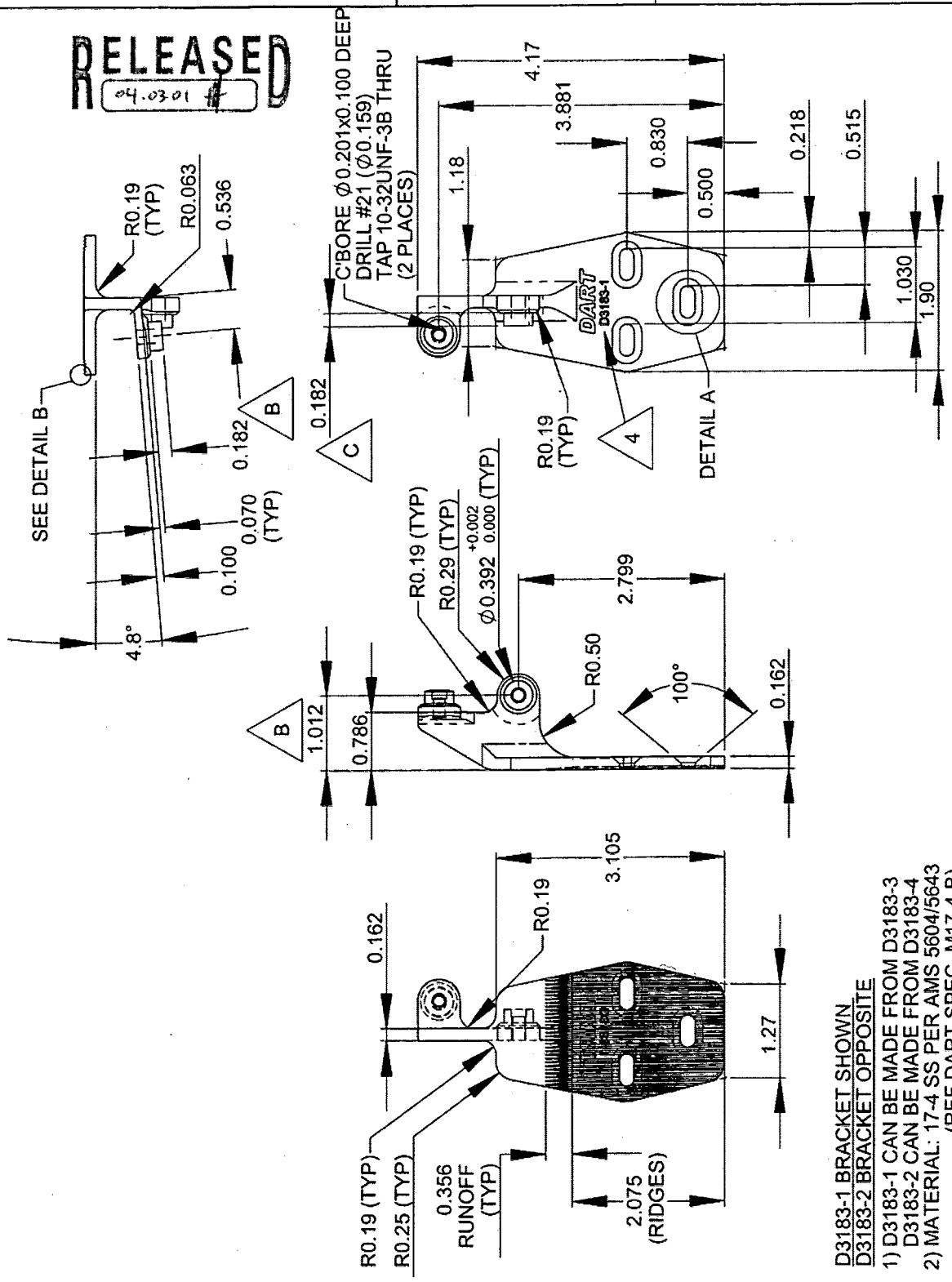
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

DART

OK COPY ISSUED

RELEASED 04.0301



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ENGRAVE DART P/N & LOGO AS SHOWN
5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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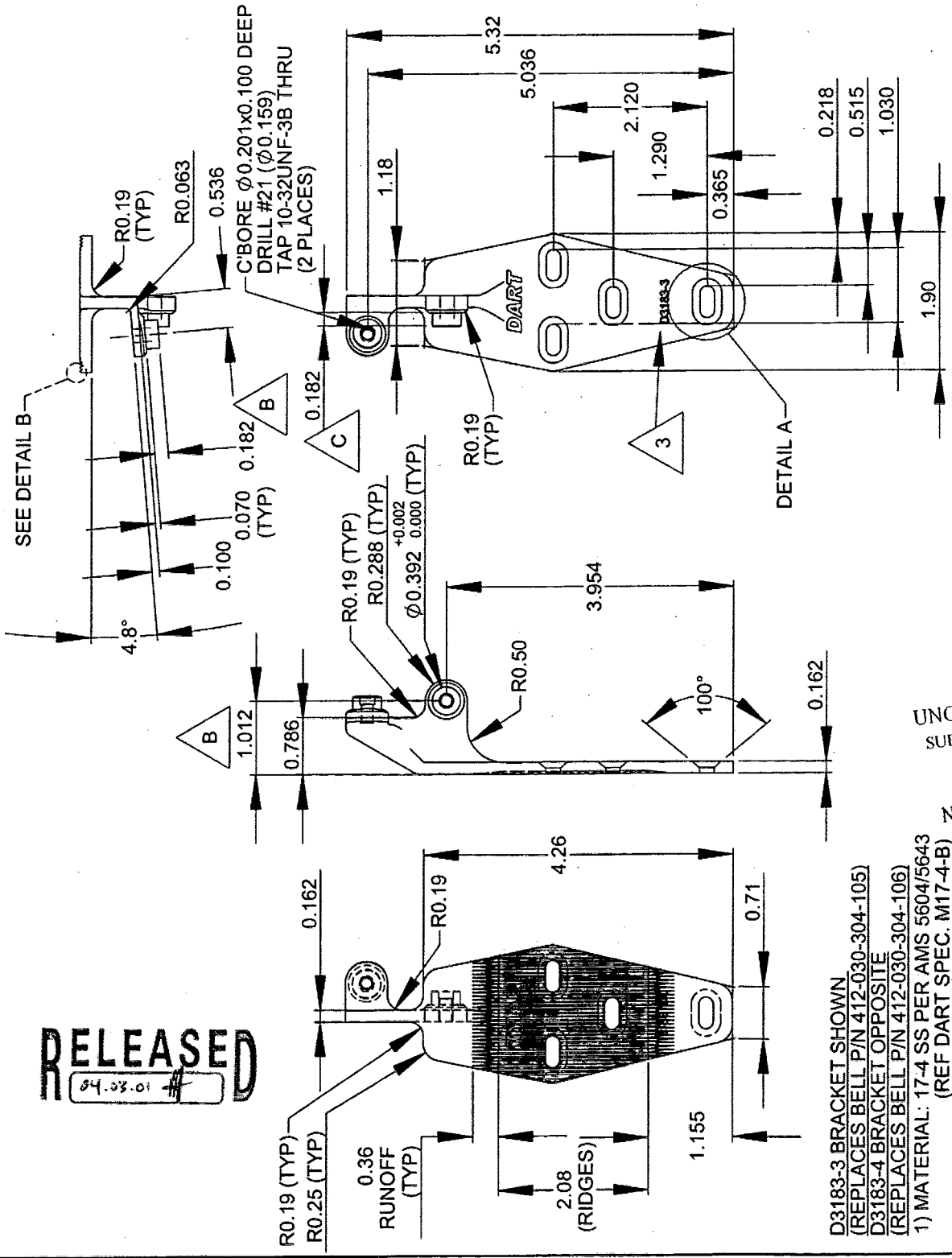
WITHOUT NOTICE
WORK ORDER #16823

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 3 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



RELEASED
04.03.01

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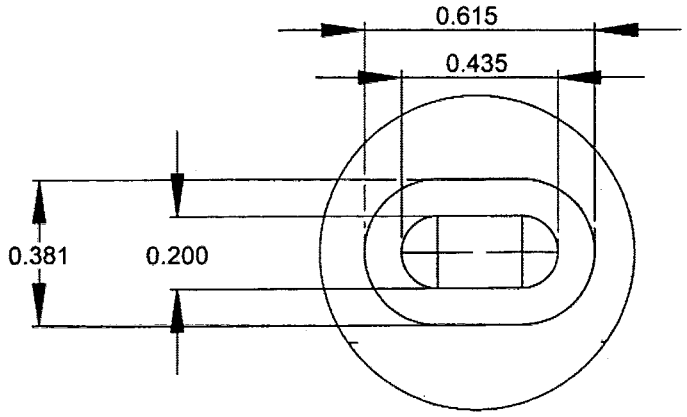
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

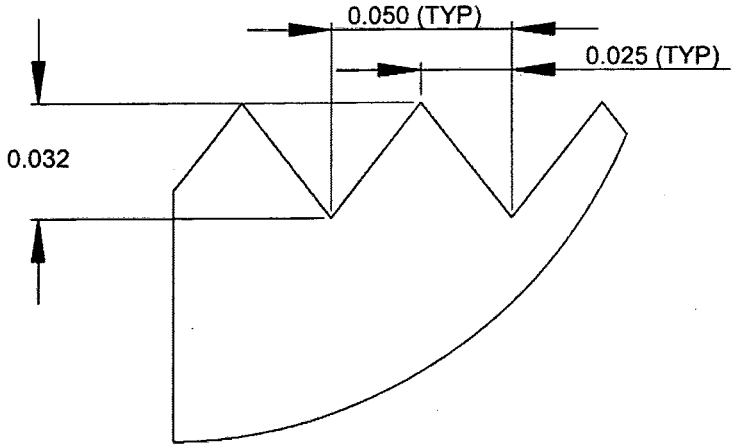
D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)
1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

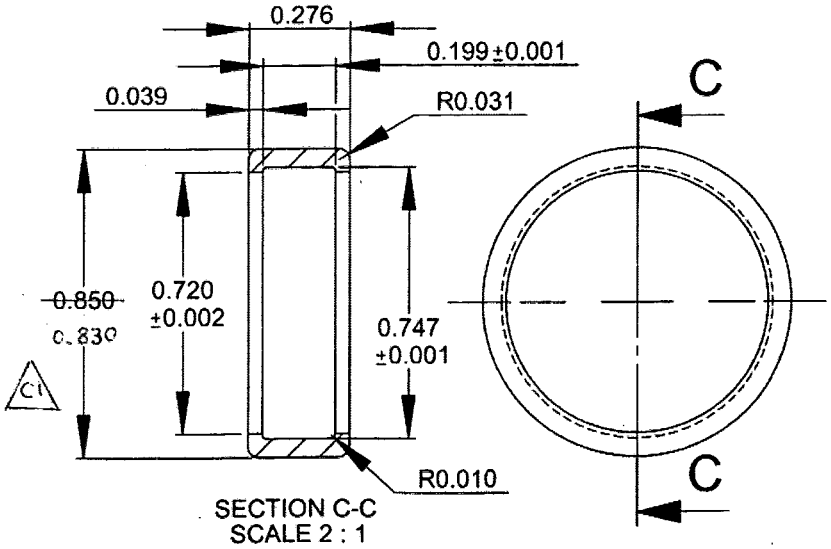


DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)



SECTION C-C
SCALE 2 : 1

D3183-9 CAP

1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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WITHOUT NOTICE
WORK ORDER
NO. 146853

1313611

cie GENERAL BEARING SERVICE inc.

www.gbs.ca

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979094

ORDER DATE: APR 7, 2009

SOLD TO: DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON. K6A-1K7

SALE MADE BY: DR
SHIP VIA:

CUSTOMER ORDER #: 00008505

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6800-ZZ	BALL BEARING	~~40~~	40	4.89	195.60
6900-ZZ	BALL BEARING	50	50	4.89	244.50
				G.S.T.	22.01

09/04/08

PACKING SLIP NO: 786661-0

RECEIVED BY: Robert Beaudoin

1313612

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